

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 162457

Tuesday, June 06, 2017 4:57:33 PM

162457

Page 2

Item ID: 646.4001 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AS350 Cable Cutter System
Start Date: 6/6/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/14/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Identify as per dwg & Stock Location: <u>Fg102</u> Packaging	0.00							
	Memo	0.00							
	Identify and pack for shipping as per PPP 646.4001 Location: _____								
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.10							

DAS
28
9-89
JUN 23 2017

17/6/27 JH

DAS
21
9-89
JUN 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

Picklist Print

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM
IPP REV:B 15.01.08 AS PER DWG REV.B DD VERF:JLM IPP
REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

600.0129

Purchased

No

100

f

264.0000

8

8

600 0129

VHB TAPE 75935A651

**

DAS
9-89 JUN 21 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK096

264

m135867

48

m137700

216

600.0990

Purchased

No

100

Each

24.0000

1

1

600 0990

Magnabond 6398 Part A Size 112 ml

**

137712

DAS
27
9-89

Location

Loc Qty

Loc Code

PKG

24

M136586

1

M136862

1

M137073

9

M137495

12

M134249

1

1/1/2017

DAS
28
9-89

WP 01/02/2018

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

600.0991 Purchased No

100 Each 24.0000

1 1

600 0991

Magnabond 6398 Part B Size 112 ml

**

137712

DAS
27
9-89

Location

Loc Qty

Loc Code

PKG

24

m136586

2

m136862

1

m137073

9

m137495

12

m134249

0

1/1/2017

600.1012 Purchased No

100 Each 31.0000

1 1

600 1012

Sealant PR1425B2 (#654 sem)

**

DAS
6
9-89

JUN 20 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

cck017

31

m136838

1

m137321

2

m137371

14

m137699

14

600.1013 Purchased No

100 Each 90.0000

5 5

600 1013

021200-3M TAPE PRIMER 94 PRIMER 24216

**

DAS
5
9-89

JUN 21 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK096

90

m136345

15

m137150

25

m137500

50

Picklist Print

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

646.2910 Manufactured No

100 Each 6.0000

646 2910

Deflector

** 1 1

DAS JUN 20 2017
6 27
9-89 9-89

Location

Loc Qty

Loc Code

CCK050

6

155356

6

646.3001 Manufactured No

100 Each 2.0000

646 3001

Lower Cable Cutter Assembly

** 1 1

DAS JUN 20 2017
6 27
9-89 9-89

Location

Loc Qty

Loc Code

cck018

2

160179

2

646.3110 Manufactured No

100 Each 0.0000

646 3110

Channel

** 1 1
2/2/2019

DAS JUN 21 2017
6 27
9-89 9-89

646.3210 Manufactured No

100 Each 8.0000

646 3210

Support

** 1 1

DAS JUN 20 2017
6 27
9-89 9-89

Location

Loc Qty

Loc Code

cck020

8

155378

2

157802

6

646.3301 Manufactured No

100 Each 7.0000

646 3301

Upper Cutter Assembly

** 1 1

DAS JUN 20 2017
6 27
9-89 9-89

Location

Loc Qty

Loc Code

cck018

7

159679

7

4/10/2018

Picklist Print

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Page 210

Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

646.3510 Manufactured No

100 Each

5.0000

1 1

646 3510

Strut

**

DAS

6

9-89

JUN 2 2017

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

cck104

5

156767

5

646.3511

Manufactured No

100

Each

0.0000

1 1

646 3511

Strut

**

DAS

6

9-89

137789

JUN 2 2017

DAS

27

9-89

DAS
28
9-89

646.3610

Manufactured No

100

Each

11.0000

1 1

646 3610

Filler

**

DAS

6

9-89

JUN 2 1 2017

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

cck104

11

156880

11

646.3710

Manufactured No

100

Each

15.0000

1 1

646 3710

Doubler

**

DAS

6

9-89

JUN 2 2017

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CKK006

15

152594

15

646.3711

Manufactured No

100

Each

4.0000

1 1

646 3711

Clip

**

DAS

6

9-89

JUN 2 1 2017

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

cck104

4

156840

4

Picklist Print

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

646.3712

Manufactured No

100

Each

6.0000

1 1

646 3712

Clip

**

DAS

DAS

27

9-89

JUN 21 2017

6

9-89

Location

Loc Qty

Loc Code

cck104

6

156884

6

646.3713

Manufactured No

100

Each

6.0000

1 1

646 3713

Gusset

**

DAS

DAS

27

9-89

6

9-89

JUN 21 2017

Location

Loc Qty

Loc Code

cck105

6

156776

6

646.3714

Manufactured No

100

Each

6.0000

1 1

646 3714

Gusset

**

DAS

DAS

27

9-89

6

9-89

JUN 20 2017

Location

Loc Qty

Loc Code

cck105

6

156761

6

646.3715

Manufactured No

100

Each

0.0000

2 2

646 3715

Strut Doubler

**

DAS

DAS

27

9-89

JUN 21 2017

6

9-89

Location

Loc Qty

Loc Code

cck105

5

156773

5

646.3716

Manufactured No

100

Each

5.0000

1 1

646 3716

Gauge Bracket

**

DAS

DAS

27

9-89

JUN 21 2017

6

9-89

Location

Loc Qty

Loc Code

cck105

5

156773

5

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1:00

Required Qty: 1:00

646.3717 Manufactured No

100 Each 1.0000

646 3717

Doubler

DAS
28
9-89

Location

cck105

Loc Qty

1

Loc Code

155481

1

24.0000

100 Each

**

JUN 2 1 2017

DAS
6
9-89

DAS
27
9-89

646.3718 Manufactured No

646 3718

Custom Washer

DAS
28
9-89

Location

cck105

Loc Qty

24

Loc Code

159350

24

27.0000

100 Each

**

JUN 2 1 2017

DAS
6
9-89

DAS
27
9-89

646.3719 Manufactured No

646 3719

Doubler

DAS
28
9-89

Location

cck105

Loc Qty

27

Loc Code

156810

2

159348

25

2.0000

100 Each

**

JUN 2 1 2017

DAS
6
9-89

DAS
27
9-89

646.3810 Manufactured No

646 3810

Bracket

DAS
28
9-89

Location

CCK106

Loc Qty

2

Loc Code

154964

2

**

JUN 2 1 2017

DAS
6
9-89

DAS
27
9-89

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

646.3811 Manufactured No

100 Each 2.0000

646 3811

Radius Block

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK106

2

156212

2

**

JUN 21 2017

DAS
6
9-89

DAS
27
9-89

646.3812 Manufactured No

100 Each 5.0000

646 3812

Gusset Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK106

5

158489

5

**

JUN 21 2017

DAS
6
9-89

DAS
27
9-89

646.3813 Manufactured No

100 Each 7.0000

646 3813

AS350 Strut Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK106

7

156801

2

157787

5

**

JUN 21 2017

DAS
6
9-89

DAS
27
9-89

646.3910 Manufactured No

100 Each 0.0000

646 3910

Shim

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK106

5

126229

5

**

159854 JUN 21 2017

DAS
6
9-89

DAS
27
9-89

646.3911 Manufactured No

100 Each 5.0000

646 3911

Shim

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK106

5

126229

5

**

JUN 21 2017

DAS
6
9-89

DAS
27
9-89

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

646.3912 Manufactured No

100 Each

39.0000

4 4

646 3912

Shim

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK106

39

159357

19

159793

20

**

DAS
6
9-89

DAS
27
9-89

JUN 21 2017

646.3913 Manufactured No

100 Each

44.0000

1 1

646 3913

Shim

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK106

44

126060

44

**

DAS
6
9-89

DAS
27
9-89

JUN 21 2017

646.9410 Manufactured No

100 Each

53.0000

1 1

646 9410

Shim

DAS
28
9-89

Location

Loc Qty

Loc Code

cck011

53

140671

53

**

DAS
6
9-89

DAS
27
9-89

JUN 21 2017

647.0112 Manufactured No

100 Each

35.0000

2 2

647 0112

Strut Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK106

35

159844

35

**

DAS
6
9-89

DAS
27
9-89

JUN 21 2017

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

647.7703 Manufactured No

100 Each 5.0000

647 7703

Strut Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK114

5

159680

5

**

DAS
6
9-89

JUN 20 2017

DAS
27
9-89

650.9201 Manufactured No

100 Each 24.0000

650 9201

Eyelet Bracket Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

cck127

24

156828

14

157798

10

**

DAS
6
9-89

JUN 21 2017

DAS
27
9-89

AN3-11A Purchased No

100 Each 220.0000

AN3-11A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

100

m136192

100

ST349

120

153855

120

**

DAS
6
9-89

JUN 21 2017

DAS
27
9-89

AN3-12A Purchased No

100 Each 183.0000

AN3-12A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST349

183

153854

183

**

DAS
6
9-89

JUN 21 2017

DAS
27
9-89

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-13A Purchased No

100 Each 26.0000

1 1

AN3-13A

Bolt

**

JUN 20 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

14

m127070

14

ST349

12

153845

12

AN316C4R Purchased No

100 Each 7.0000

2 2

AN316C4R

Nut, Jam

**

JUN 20 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST331

7

153850

7

AN3-3A Purchased No

100 Each 90.0000

4 4

AN3-3A

Bolt

**

JUN 20 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST350

90

m137391

8

m137597

82

AN3-4A Purchased No

100 Each 341.0000

10 10

AN3-4A

Bolt

**

JUN 20 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST350

341

m137478

341

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-5A	Purchased	No	100	Each	211.0000	2	2	JUN 20 2017	DAS 6 9-89	DAS 27 9-89
AN3-5A										
Bolt										
DAS 28 9-89										
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
			ST350		211					
			m136986		211					
AN3-6A	Purchased	No	100	Each	167.0000	2	2	JUN 20 2017	DAS 6 9-89	DAS 27 9-89
AN3-6A										
Bolt										
DAS 28 9-89										
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
			ST350		167					
			m137412		167					
AN44-5A	Purchased	No	100	Each	17.0000	2	2	JUN 20 2017	DAS 6 9-89	DAS 27 9-89
AN44-5A										
Eyebolt										
DAS 28 9-89										
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
			ST339		17					
			m137075		5					
			m137507		12					
AN4C7A	Purchased	No	100	Each	93.0000	2	2	JUN 20 2017	DAS 6 9-89	DAS 27 9-89
AN4C7A										
BOLT										
DAS 28 9-89										
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
			OVER002		75					
			m137361		75					
			ST345		18					
			m136295		18					

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Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

AN665-34R Purchased No

100 Each 12.0000 2 2

AN665-34R

Clevis

**

JUN 20 2017

DAS 6

DAS 27 9-89

DAS 3 9-89

Location

Loc Qty

Loc Code

ST330

12

m137361

2

m137587

10

CCR264SS3-02 Purchased No

100 Each 2.0000 36 36

CCR264SS3-02

Cherry Rivet

**

JUN 20 2017

DAS 6

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST321

2

M137361

2

CR3213-5-3 Purchased No

100 Each 158.0000 14 14

CR3213-5-3

Cherry Rivet

**

JUN 20 2017

DAS 6

DAS 27 9-89

DAS 2 9-89

Location

Loc Qty

Loc Code

ST319

158

m136851

2

m137320

100

m137391

56

MS20426AD5-7 Purchased No

100 Each 1,388.000 2 2

MS20426AD5-7

RIVET

**

JUN 20 2017

DAS 6

DAS 27 9-89

DAS

Location

Loc Qty

Loc Code

CCK004

703

153848

703

ST311

685

M133922

685

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Shop Packet Print

Page 218

Picklist Print

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Page 219

Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

MS20470AD5-5.5

Purchased

No

100

Each

638.0000

8

8

MS20470AD5-5 5

Rivet

**

JUN 20 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST309

638

m134063

638

MS20470AD5-6

Purchased

No

100

Each

528.0000

8

8

MS20470AD5-6

RIVET

**

JUN 20 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST309

528

124089

528

MS20470AD5-7

Purchased

No

100

Each

344.0000

3

3

MS20470AD5-7

Rivet

**

JUN 20 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST309

344

123425

344

MS21042-08

MS21042L08

Purchased

No

100

Each

0.0000

2

2

MS21042-08

USE MS21042L08

**

JUN 20 2017

DAS
6
9-89

DAS
27
9-89

MS21042-3

MS21042L3

Purchased

No

100

Each

0.0000

2

2

MS21042-3

Nut

**

JUN 20 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

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Shop Packet Print

Page 219

Picklist Print

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Page 220

Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

1,989.000

61

61

MS21042I 3

Nut

**

DAS
6 JUN 12.0.2017
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

79

m135945

79

GA

434

m134360

102

M136665

332

OVER007

1000

m134360

0

m137680

1000

ST303

476

m137321

4

m137495

472

61

MS21042L4

Purchased

No

100

Each

3,041.000

2

2

MS21042I 4

Nut

**

DAS
6 JUN 20 2017
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

51

m135058

51

OVER007

2400

m137402

400

m137544

1000

m137680

1000

ST303

580

m137771

580

2

2

Picklist Print

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Page 221

Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

MS21047-3

Purchased

No

100

Each

161.0000

18

18

MS21047-3

Nut Plate

**

JUN 20 2017

DAS

6

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST301

161

m137075

11

m137459

150

MS24693-C278

Purchased

No

100

Each

120.0000

5

5

MS24693-C278

Screw

**

JUN 20 2017

DAS

6

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST287

120

m136554

20

m137680

100

MS24694-S51

Purchased

No

100

Each

270.0000

5

5

MS24694-S51

Screw

**

JUN 20 2017

DAS

6

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST284

270

m135442

20

m136866

250

MS24694-S54

Purchased

No

100

Each

61.0000

2

2

MS24694-S54

SCREW

**

JUN 20 2017

DAS

6

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST284

61

153846

61

DAS

28

9-89

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Shop Packet Print

Page 221

Picklist Print

Monday, June 05, 2017 4:53:53 PM

Page 222

Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

MS24694-S55

Purchased

No

100

Each

226.0000

3

3

MS24694-S55

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST283

226

153847

226

100

Each

275.0000

2

2

MS27039-08-13

Purchased

No

MS27039-08-13

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST278

275

153849

275

100

Each

485.0000

2

2

MS27039-1-10

Purchased

No

MS27039-1-10

SCREW

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

15

m129541

15

over006

300

m137597

300

ST280

170

m137164

170

MS27039-1-12

Purchased

No

MS27039-1-12

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST280

51

m136537

1

m137320

50

51.0000

6

6

JUN 20 2017

JUN 20 2017

JUN 20 2017

JUN 20 2017

DAS
27
9-89

DAS
6
9-89

DAS
27
9-89

DAS
6
9-89

DAS
27
9-89

DAS
6
9-89

DAS
27
9-89

DAS
6
9-89

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Shop Packet Print

Page 222

Picklist Print

Monday, June 05, 2017 4:53:53 PM

Page 223

Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-16

Purchased

No

100

Each

73.0000

24

24

MS27039-1-16

Screw

**

JUN 20 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

over006

50

m137061

50

ST280

23

m137320

23

137736

MS27039-1-19

Purchased

No

100

Each

369.0000

22

22

MS27039-1-19

Screw

**

JUN 20 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

80

m134134

80

ST280

289

m137361

289

22

MS27039-1-20

Purchased

No

100

Each

65.0000

2

2

MS27039-1-20

Screw

**

JUN 20 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST280

65

m136554

65

2

MS27039-1-21

Purchased

No

100

Each

135.0000

4

4

MS27039-1-21

Screw

**

JUN 20 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST280

135

m127904

135

4

Picklist Print

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Page 224

18

Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

JUN 7 0 2017

NAS1149F0332P

Purchased

No

100

Each

1,507.000

144

144

NAS1149F0332P

Washer

**

DAS

6

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

GA

275

m133709

275

ST262

1232

m137075

13

m137412

1219

DAS
28
9-89

NAS1149F0363P

Purchased

No

100

Each

244.0000

2

2

NAS1149F0363P

WASHER

**

DAS

6

9-89

JUN 2 0 2017

DAS

27

9-89

Location

Loc Qty

Loc Code

ST262

244

124555

44

m137544

200

DAS
28
9-89

NAS1149F0432P

Purchased

No

100

Each

1,415.000

4

4

NAS1149F0432P

WASHER

**

DAS

6

9-89

JUN 2 0 2017

DAS

27

9-89

Location

Loc Qty

Loc Code

ST260a

1000

M137412

1000

ST262

415

M137361

415

DAS
28
9-89

Picklist Print

Monday, June 05, 2017 4:53:53 PM

Page 225

Work Order ID: 162457

162457

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017

Required Date: 6/14/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

100

Each

1,771.000

4

4

**

DAS
6
9-89

JUN 20 2017

DAS
27
9-89

NAS1149FN832P

Washer

DAS

Location

Loc Qty

Loc Code

GA

358

M135058

208

M136182

40

M136866

110

ST263

1413

M137412

1413



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05304

SHEET 1 OF 1

DWG NO. 646.4000

REV: C

PREPARED BY J. BECKER

DATE: 02/04/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: AS350 CABLE CUTTERS KIT

APPROVED BY: ENGR

MFG

QC

EFF: NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED F/N 12.

ECR: N/A

ACTION ITEM:
1. N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162457

20170607

SHEET 1, BOM IS:

12	R	601.1624	8	16	LOCKNUT	MS21042L3	
F/N	TC	PART NUMBER	4006	4005	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY				
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM						☐ MAJOR ☒ MINOR	☐ YES ☒ NO

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2. INSTALL F/N 14 WITH F/N 52 & 53.

3. 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 7593A651.

4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5. REUSE FASTENERS FROM F/N 1.

6. USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7. AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES: USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9. NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

	5		5	78	601.3875	SCREW				
	1		1	77	646.9410	SHIM				
			4	76	601.2764	WASHER		NAS1149H032P		
			2	75	601.2973	LOCKNUT		MS21042-08		
			2	74	601.2988	SCREW		MS27039-0813		
			2	73	601.2943	LOCKNUT		MS21042-3		
			2	72	601.3128	NUT		AN316CAR		
			2	71	601.3209	LOCKNUT		MS21042-4		
			4	70	601.2638	WASHER		NAS1149H032P		
			2	69	601.2669	BOLT		ANAC7A		
			2	68	601.3119	CLEVIS		AN6A5-34R		
			2	67	601.3121	EYE BOLT		AN6A-5A		
			2	66	650.9201	EYE BRACKET ASSY				
	REF	REF	REF	65	647.5701	GPS MOUNT KIT				
			2	64	601.3151	WASHER		NAS1149H032P		
		2		63	601.2911	SCREW		MS24694053		
		24	24	62	601.2637	SCREW		MS27039-1-16		
	2	2	2	61	601.2763	BOLT		AN3-12A		
		1	1	60	646.3913	SHIM				
		4	4	59	646.3912	SHIM				
		1	1	58	646.3911	SHIM				
		4	4	57	646.3910	SHIM				
		5	5	56	600.1013	PRIMER				
	8 FT		8 FT	55	600.0129	VHB TAPE				
		1	1	54	600.1012	SEALANT		PR-1425 CLASS B		
		1	1	53	600.0991	MAGNIBOND 6398 PART B				
		1	1	52	600.0990	MAGNIBOND 6398 PART A				
	6	10	10	51	601.2826	BOLT		AN3-11A		
			2	50	646.3814	WIPER BRACKET				
			2	49	601.2910	SCREW		MS27039-1-16		
	2		2	48	601.1365	SCREW		MS27039-1-10		
	2		2	47	646.3719	DOUBLER				
		2	2	46	646.3718	CUSTOM WASHER				
	1		1	45	646.3717	DOUBLER				
		22	22	44	601.1948	SCREW		MS27039-1-19		
		2	2	43	601.1952	SCREW		MS27039-1-20		
			4	42	601.1956	SCREW		MS27039-1-21		
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 021112, 021113, 021114 & 021115	02/08/2010	P. BRAYO
B	INCORPORATED ECN 021112, 021113 & 021114	11/04/2014	P. BRAYO
C	INCORPORATED ECN 021112	07/09/2015	P. BRAYO

		2		2	41	601.2829	SCREW	MS24694054		
		2		2	40	601.2831	RIVET	MS20426ADS-7		
		1		1	39	646.3716	GAUGE BRACKET			
		6		6	38	601.1953	SCREW	MS27039-1-12		
	2	2		2	37	646.3715	STRUT DOUBLER			
		2		2	36	601.2824	BOLT	AN3-5A		
12	36			36	35	601.2277	RIVET	COR04850-02		
6	18			18	34	600.0795	NUTPLATE	MS21047-3		
3	3			3	33	601.2565	RIVET	MS20470ADS-7		
1	1			1	32	646.3813	STRUT BRACKET			
4	4			4	31	601.2822	BOLT	AN3-3A		
2	2			2	30	646.3812	GUSSET BRACKET			
8	8			8	29	601.2564	RIVET	MS20470ADS-6		
1	1			1	28	646.3714	GUSSET			
	1	1		1	27	646.3610	FILLER			
	3	3		3	26	601.2830	SCREW	MS24694055		
	2	2		2	25	601.2825	BOLT	AN3-6A		
	1	1		1	24	646.3811	RADIUS BLOCK			
	1	1		1	23	646.3712	CLIP			
	1	1		1	22	646.3711	CLIP			
8	8			8	21	601.2832	RIVET	MS20470ADS-5		
14	14			14	20	601.2020	RIVET	CR3213-5-3		
4	6	4	6	10	19	601.2823	BOLT	AN3-4A		
	1	1		1	18	601.2827	BOLT	AN3-13A		
	5	5		5	17	601.2912	SCREW	MS24694051		
1	1			1	16	646.3713	GUSSET			
1	1			1	15	646.3210	SUPPORT			
	1			1	14	646.3710	DOUBLER			
	1	1		1	13	646.3110	CHANNEL			
14	10	8	53	6	61	601.1624	LOCKNUT	MS21042L3		
16	32	16	120	16	144	601.1607	WASHER	NAS1149H032P		
				1	10	646.3410	LH WIPER DEFLECTOR			
				1	9	646.3411	RH WIPER DEFLECTOR			
		2		2	8	647.7703	STRUT ASSY			
		2		2	7	647.0112	STRUT BRACKET			
	1	1		1	6	646.3511	STRUT			
	1	1		1	5	646.3510	STRUT			
2		2		2	4	646.3810	BRACKET			
		1		1	3	646.2910	DEFLECTOR			
	1	1		1	2	646.3001	LOWER CUTTER ASSY			
	1	1		1	1	646.3301	UPPER CUTTER ASSY			
X						646.4006	LOWER CUTTER FIXED PROVISIONS			
	X					646.4005	LOWER CUTTER REMOVABLE PROVISIONS			
		X				646.4004	FIXED PROVISIONS KIT			
			X			646.4003	CABLE CUTTERS KIT WITHOUT FIXED PROVISIONS			
				X		646.4002	ASS350 WIPER DEFLECTOR KIT			
					X	646.4001	ASS350 CABLE CUTTERS KIT			
4004	4003	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

GTY		NEXT ASSY (S)		ORIGINAL DATE (INC-DATE) 08/27/08	DESIGNED BY P. BRAYO	APPROVED BY P. BRAYO	DATE 08/27/08	PARTS LIST	
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS: .001 2 PLACE DECIMALS: .005 ANGLES: ± .5°		DART 3030 ENTERPRISE CT., SUITE A AFICAL INDUSTRIES, INC. VISTA, CA 92081 (760)-724-5300		ASS350 CABLE CUTTERS KIT	
SCALE: NONE		SHEET 1 OF 5		DWG. NO. 646.4000		REV. C			

DQA: _____ Date: _____



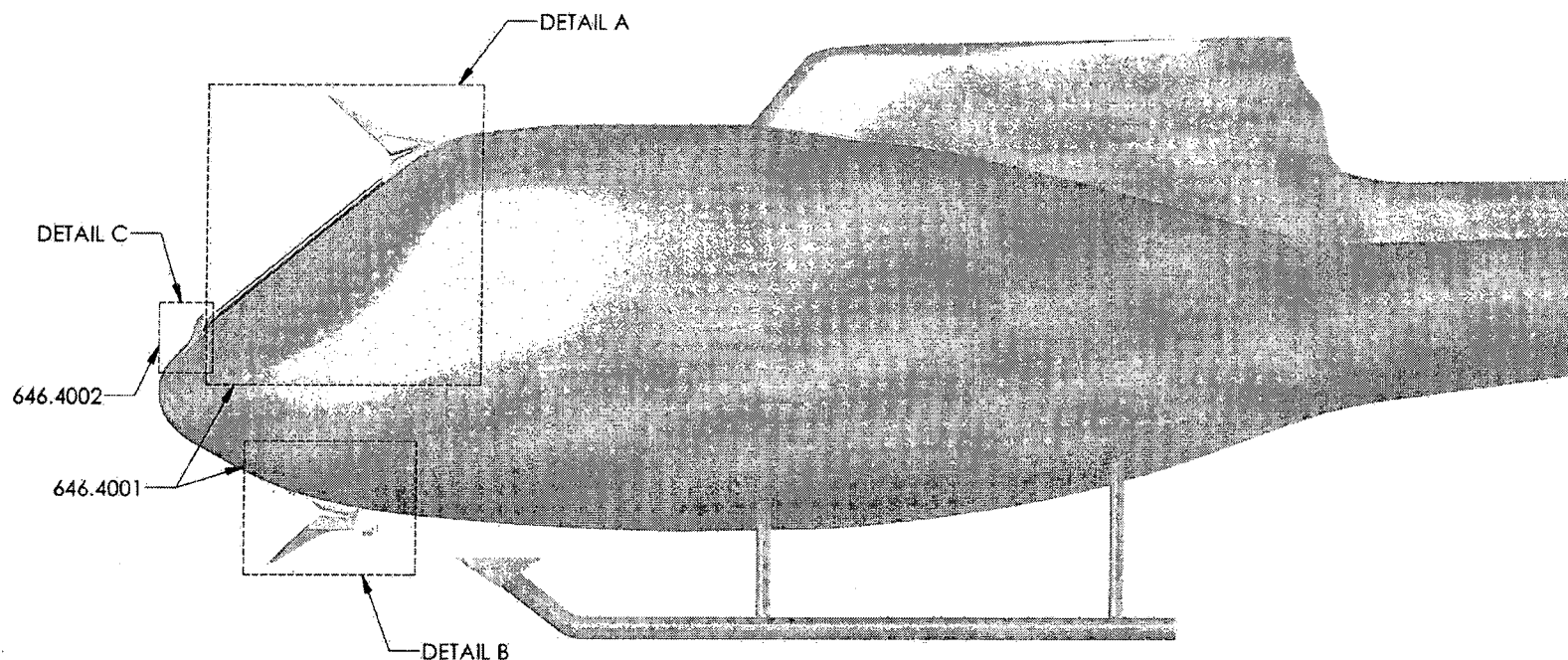
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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ORIGINAL DATE (MM-DD-YY) 06-27-06 DRAWN BY S. HUFF P. BRAVO DRAWING APPROVAL P. BRAVO 06-27-06 CONTRACT NO.		DART 3030 ENTERPRISE CT. SUITE A AEROSPACE VISTA, CA 92081 APICAL INDUSTRIES, INC. DBA DART AEROSPACE (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.010 2 PLACE DECIMALS ±.005 ANGLES ± .5°		AS350 CABLE CUTTERS KIT REV. C 646.4000 SCALE NONE SHEET 2 OF 3	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
OTHER : ☐																									

DQA: _____ Date: _____

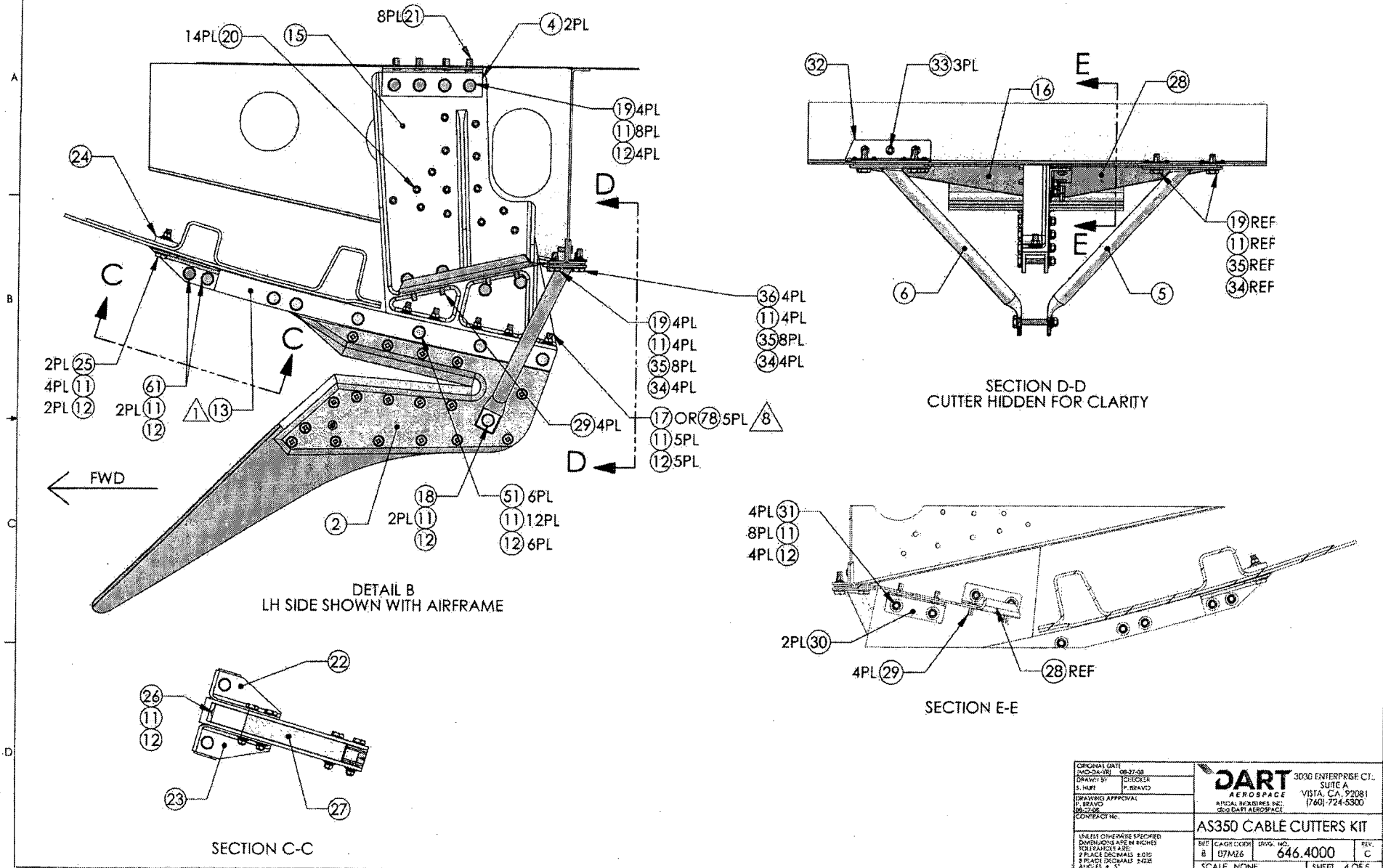
**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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DQA: _____ Date: _____



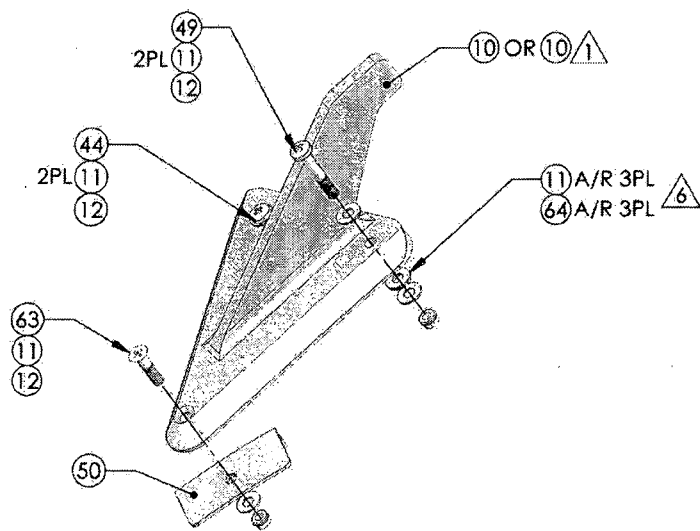
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

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DETAIL C
LH SHOWN EXPLODED
RH OPPOSITE

ORIGINAL DATE 08-27-08		DART AEROSPACE 3030 ENTERPRISE CT. VISTA, CA 92081 (760)-724-5300	
DRAWN BY S. HOFF		SURE A	
CHECKED BY P. BRAVO		AFICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAVO 08-27-08		AS350 CABLE CUTTERS KIT	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TO FRACTIONS 2 PLACE DECIMALS ± 0.05 3 PLACE DECIMALS ± 0.005 ANGLES ± 5°		SHEET 5 OF 5	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

REFERENCE ONLY

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NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2. INSTALL F/N 14 WITH F/N 52 & 53.

3. 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASSTER-CARR P/N 75935A651.

4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5. REUSE FASTENERS FROM F/N 1.

6. USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7. AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9. NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	*78	601.3875	SCREW	UNINCORPORATED				
1	1	1	*77	646.9410	SHIM					
	4	4	76	601.2764	WASHER	NAS11491B32P				
	2	2	*75	601.2973	LOCKNUT	MS27039-0813				
	2	2	74	601.2988	SCREW	MS27039-0813				
	2	2	*73	601.2943	LOCKNUT	MS21042-3				
	2	2	*72	601.3128	NUT	AN316CAR				
	2	2	71	601.3209	LOCKNUT	MS27042-3A				
	4	4	*70	601.2636	WASHER	NAS11491G452P				
	2	2	*69	601.2669	BOLT	AN316CAR				
	2	2	*68	601.3119	CLEVIS	AN316CAR				
	2	2	*67	601.3121	EYE BOLT	AN316CAR				
	2	2	*66	650.9201	EYE BRACKET ASSY					
REF	REF	REF	*65	647.5701	GPS MOUNT KIT					
		2	64	601.3151	WASHER	NAS11491G363P				
		2	63	601.2911	SCREW	MS27039-0813				
	24	24	62	601.2637	SCREW	MS27039-0813				
2	2	2	61	601.2763	BOLT	AN316CAR				
	1	1	*60	646.3913	SHIM					
	4	4	59	646.3912	SHIM					
	1	1	58	646.3911	SHIM					
	4	4	57	646.3910	SHIM					
	5	5	56	600.1013	PRIMER					
	8 FT	8 FT	55	600.0129	VHB TAPE					
	1	1	54	600.1012	SEALANT	PRIMER CLASS B				
	1	1	53	600.0991	MAGNABOND 6598 PART B					
	1	1	52	600.0990	MAGNABOND 6598 PART A					
6	10	10	51	601.2826	BOLT	AN316CAR				
		2	50	646.3814	WIPER BRACKET					
		2	49	601.2910	SCREW	MS27039-0813				
	2	2	*48	601.1365	SCREW	MS27039-0813				
	2	2	47	646.3719	DOUBLER					
		2	46	646.3718	CUSTOM WASHER					
	1	1	45	646.3717	DOUBLER					
		22	44	601.1948	SCREW	MS27039-0813				
		2	43	601.1952	SCREW	MS27039-0813				
		4	42	601.1956	SCREW	MS27039-0813				
4006	4003	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

										REVISIONS		DATE	APPROVED
										REV.	DESCRIPTION		
										A	INCORPORATED ECN 0011, 0015, 0016, 0017 & 0018	02/02/2018	P. BRAVO
										B	INCORPORATED ECN 0016, 0017 & 0018	11/04/2018	P. BRAVO
										C	INCORPORATED ECN 0019	09/05/2019	P. BRAVO

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Work Order ID 162457

Tuesday, June 06, 2017 4:57:33 PM

162457

Page 1

Item ID: 646.4001

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: AS350 Cable Cutter System

Start Date: 6/6/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/14/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

20170607

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.4000	C1								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 646.4001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS
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JUN 19 2017

United States Of America
Department of Transportation - Federal Aviation Administration

Supplemental Type Certificate

Number SR02180LA

This Certificate issued to: Apical Industries, Inc. dba Dart Aerospace
3030 Enterprise Court, Suite A
Vista, CA 92081

certifies that the change in the type design for the following product with the limitations and conditions therefore as specified hereon meets the airworthiness requirements of Part 27* of the Federal Aviation Regulations.

*Certification basis is set forth in Type Certificate Data Sheet H9EU.

Original Product Type Certificate Number: H9EU

Make: Eurocopter France

Model: AS350 C, D, D1, B, B1, B2, BA, B3

Description of Type Design Change: Installation of a Cable Cutter Kit in accordance with FAA approved Apical Master Document List, MD350-61, Revision A, dated November 25, 2008, or later FAA approved revision.

Limitations and Conditions: The installation should not be incorporated in any aircraft unless it is determined that the interrelationship between this installation and any previously approved configuration will not introduce any adverse effect upon the airworthiness of the aircraft. The approval of this modification applies to the above noted aircraft model series only. This approval requires the inspections and overhaul schedules to be performed as mandated by Apical Industries, Inc.'s Instructions for Continued Airworthiness, ICA350-61, Revision N/C, dated November 20, 2008, or later FAA accepted revision. A copy of this STC must be included in the permanent records of the modified aircraft. If the holder agrees to permit another person to use this certificate to alter the product, the holder shall give the other person written evidence of that permission.

This certificate and the supporting data which is the basis for approval shall remain in effect until surrendered, suspended, revoked or a termination date is otherwise established by the Administrator of the Federal Aviation Administration.

Date of application: May 21, 2008

Date received: August 7, 2014

Date of issuance: December 16, 2008

Date amended:

By direction of the Administrator



Haifa Haj-Eid
(Signature)

Haifa Haj-Eid
Supervisor, Technical and Administrative
Support Staff
Los Angeles Aircraft Certification Office

(Title)

Any alteration of this certificate is punishable by a fine of not exceeding \$1,000, or imprisonment not exceeding 3 years, or both.